

Ship Sept. 12

Work Order ID 165245

165245

Page 1

Thursday, August 17, 2017 9:12:12 AM

Item ID: D412-711-021 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/12/2017 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan:  Date: AUG 17 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-711	L

AUG 21 2017

DAS
6
9-89

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefiles and create labels per PPP D412-711-021 CHG002

DAS
27
9-89

SEP 08 2017

120 Pick Kit 0.00
 120 Purchasing
 Packaging Memo 0.00
 Packaging

AUG 22 2017

DAS
28
9-89

130 QC4- 100% Inspect kits for completeness 0.00
 130 QC Memo 0.03
 Quality Control

DAS
27
9-89

SEP 08 2017

Work Order ID 165245

Thursday, August 17, 2017 9:12:12 AM

165245

Page 2

Item ID: D412-711-021**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Vertical Reference Door Modification LH**Start Date:** 8/28/2017 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 9/12/2017 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00				DAS 27 9-89			
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-711-021 Location: _____ PPP rev: _____ fg099								
									SEP 08 2017
160	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			
160									SEP 11 2017
QC	Memo	0.10							
Quality Control						DAS 21 9-89			SEP 11 2017

Picklist Print

Thursday, August 17, 2017 9:12:11 AM

Page 1

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.04.07 new issue DD verf:EC
14.04.25 ECN14-548 DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4324-011		Manufactured	No			120	Each	2.0000	1	1			
D4324-011									**			AUG 22 2017	DAS 28 9-89
Armrest Assembly													

	Location	Loc Qty	Loc Code
	ST459	2	
	160694	1	
	163985	1	

D412-761-043		Manufactured	No			120	Each	1.0000	1	1			
D412-761-043									**			SEP 01 2017	DAS 28 9-89
Modified Latch Mechanism, LH													

	Location	Loc Qty	Loc Code
	FG020	1	
	160099	1	

D412-711-101		Manufactured	No			120	Each	0.0000	1	1			
D412-711-101									**			SEP 07 2017	DAS 28 9-89
Replacement Vertical Reference Window													

D3802-1-120		Manufactured	No			120	Each	0.0000	1	1			
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D3802-1-120									**				DAS 28 9-89
Window Seal -													

D4165-1		Manufactured	No			120	Each	5.0000	1	1			
D4165-1									**			AUG 22 2017	DAS 28 9-89
Doubler													

	Location	Loc Qty	Loc Code
	ST236	5	
	161419	5	

AUG 22 2017

Picklist Print

Thursday, August 17, 2017 9:12:11 AM

Page 2

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4165-3 Manufactured No

120 Each 4.0000 1 1

D4165-3

Inner Door Panel

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

4

161422

4

AUG 22 2017

DAS
28
9-89

D4165-5 Manufactured No

120 Each 3.0000 1 1

D4165-5

Aft Rib

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST236

3

161424

3

AUG 22 2017

DAS
28
9-89

D4165-7 Manufactured No

120 Each 5.0000 1 1

D4165-7

Fwd Rib

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST236

5

161417

5

AUG 22 2017

DAS
28
9-89

D4165-9 Manufactured No

120 Each 3.0000 1 1

D4165-9

Angle

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST237

3

161410

3

AUG 22 2017

DA
28
9-8

D4165-11 Manufactured No

120 Each 4.0000 1 1

D4165-11

Door Cover Panel

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST235

4

161902

4

AUG 22 2017

DAS
28
9-89

Thursday, August 17, 2017 9:12:11 AM

Shop Packet Print

Page 2

Picklist Print

Thursday, August 17, 2017 9:12:11 AM

Page 3

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4207-1

Manufactured No

120

Each

4.0000

1

1

D4207-1

Window Retainer

**

Location

Loc Qty

Loc Code

ST237

4

161967

4

D4207-3

Manufactured No

120

Each

4.0000

1

1

D4207-3

Instrument Window

**

Location

Loc Qty

Loc Code

ST237

4

163744

4

D4269-1

Manufactured No

120

Each

2.0000

1

1

D4269-1

Angle

**

Location

Loc Qty

Loc Code

ST084

2

160693

2

D4269-3

Manufactured No

120

Each

4.0000

1

1

D4269-3

Angle

**

Location

Loc Qty

Loc Code

ST084

4

160695

4

AUG 22 2017

AUG 22 2017

AUG 22 2017

AUG 22 2017

Picklist Print

Thursday, August 17, 2017 9:12:11 AM

Page 4

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

D4269-5 Manufactured No 120 Each 5.0000 1 1

D4269-5

Angle

**

AUG 22 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST237	5	
160331	1	
<u>161889</u>	4	

D4269-7 Manufactured No 120 Each 4.0000 1 1

D4269-7

Angle

**

AUG 22 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST237	4	
160332	1	
<u>161893</u>	3	

D4327-1 Manufactured No 120 Each 2.0000 1 1

D4327-1

Angle

**

AUG 22 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST237	2	
<u>163450</u>	2	

D4327-3 Manufactured No 120 Each 0.0000 1 1

D4327-3

Angle

**

SEP 01 2017

DAS
28
9-89

D4385-1 Manufactured No 120 Each 12.0000 2 2

D4385-1

Placard

**

AUG 22 2017

DAS
28
9-89

Location	Loc Qty	Loc Code
ST095	12	
<u>156112</u>	6	2/3/2018
160140	6	5/19/2018

Thursday, August 17, 2017 9:12:12 AM

Shop Packet Print

Page 4

Picklist Print

Thursday, August 17, 2017 9:12:12 AM

Page 5

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-3A Purchased No 120 Each 106.0000 22 22

AN3-3A

Bolt

**

Location	Loc Qty	Loc Code
ST350	106	
m137597	31	
m137853	50	
m138207	25	

AUG 22 2017

DAS
27
9-89

22

AN3-4A Purchased No 120 Each 430.0000 20 20

AN3-4A

Bolt

**

Location	Loc Qty	Loc Code
over003	350	
350	350	
ST350	80	
m137478	80	

AUG 22 2017

DAS
27
9-89

20

AN3-6A Purchased No 120 Each 130.0000 26 26

AN3-6A

Bolt

**

Location	Loc Qty	Loc Code
ST350	130	
m137412	130	

AUG 22 2017

DAS
27
9-89

26

AN3-12A Purchased No 120 Each 157.0000 1 1

AN3-12A

Bolt

**

Location	Loc Qty	Loc Code
ST349	157	
153854	157	

AUG 22 2017

DAS
27
9-89

1

Thursday, August 17, 2017 9:12:12 AM

Shop Packet Print

Page 5

Picklist Print

Thursday, August 17, 2017 9:12:12 AM

Page 6

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

120

Each

3,147.000

92

92

NAS1149F0332P

**

Washer

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

2872

m137710

872

m138209

2000

92

AUG 22 2017

DAS
28
9-89

DAS
27
9-89

CR3242-4-2

Purchased

No

120

Each

118.0000

34

34

CR3242-4-2

**

RIVET

Location

Loc Qty

Loc Code

ST318

118

m137061

18

m137597

100

17

17

AUG 22 2017

DAS
28
9-89

DAS
27
9-89

MS20426AD3-3

Purchased

No

120

Each

2,023.000

135

135

MS20426AD3-3

**

RIVET

Location

Loc Qty

Loc Code

FG107/108

360

M137350

80

M138217

280

fg108

200

M134946

200

ST312

1463

M135274

1463

135

AUG 22 2017

DAS
28
9-89

DAS
27
9-89

Picklist Print

Thursday, August 17, 2017 9:12:12 AM

Page 7

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-3

Purchased

No

120

Each

3,660.000

140

140

MS20426AD4-3

Rivet

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

211

113064

211

ST312

3449

m137597

3449

120

Each

5,889.000

25

25

**

AUG 22 2017

DAS
28
9-89

MS20470AD3-3

Purchased

No

MS20470AD3-3

RIVET, UNIVERSAL HEAD

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

719

1065

719

ST310

5170

16941

5170

120

Each

1,516.000

90

90

**

AUG 22 2017

DAS
28
9-89

MS20470AD4-3

Purchased

No

MS20470AD4-3

Rivet, Universal Head

**

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

794

2193

87

m135536

707

ST310

722

m135536

722

AUG 22 2017

DAS
28
9-89

Picklist Print

Thursday, August 17, 2017 9:12:12 AM

Page 8

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9/12/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

1,966.000

24

24

MS21042L3

Nut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

348

m134360

102

M136665

246

OVER007

500

m138230

500

ST303

1039

M128754

4

m134039

12

m137988

78

m138084

945

AUG 22 2017

DAS
27
9-89

MS21059L3

Purchased

No

120

Each

242.0000

4

4

MS21059L3

Nut Plate

**

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

47

M137412

1

M137659

30

M137710

16

ST301

195

M137587

4

M137820

41

M137963

50

M138040

100

AUG 22 2017

DAS
27
9-89

Thursday, August 17, 2017 9:12:12 AM

Shop Packet Print

Page 8

Picklist Print

Thursday, August 17, 2017 9:12:12 AM

Work Order ID: 165245

165245

Parent Item: D412-711-021

D412-711-021

Parent Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017

Required Date: 9.

Start Qty: 1.00

Required Qty: 1.0

MS21069L3 Purchased No 120 Each 157.0000 34 34
**
MS21069L3
ANCHOR NUT

AUG 22 2017
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST299	157	
m137459	57	
m137820	100	

34

MS21069L08 Purchased No 120 Each 410.0000 8 8
**
MS21069L08
ANCHOR NUT

AUG 22 2017
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST299	410	
123522	410	

8

MS21071L3 Purchased No 120 Each 60.0000 3 3
**
MS21071L3
ANCHOR NUT

AUG 22 2017
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
S299	50	
m137680	50	
ST299	10	
125654	10	

3

MS21071L08 Purchased No 120 Each 146.0000 1 1
**
MS21071L08
ANCHOR NUT

AUG 22 2017
DAS 28 9-89

DAS 27 9-89

Location	Loc Qty	Loc Code
ST299	146	
102587	46	
103447	100	

1

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	QTY -021	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X								D412-711-011	VERTICAL REFERENCE DOOR INSTALLATION, 212/412
	X							D205-711-013	VERTICAL REFERENCE DOOR INSTALLATION, 205/210
		X						D204-711-015	VERTICAL REFERENCE DOOR INSTALLATION, 204
			X					D214-711-017	VERTICAL REFERENCE DOOR INSTALLATION, 214
				X				D212-711-019	VERTICAL REFERENCE DOOR EAGLE SINGLE
					X			D412-711-021	VERTICAL REFERENCE DOOR KIT
^A 1	^A 1	^A 1	^A 1	^A 1		X		D412-711-041	VERTICAL REFERENCE DOOR ASSEMBLY
							X	D412-711-043	SNAP VENT KIT
					1	1		D412-761-043	MODIFIED LATCH MECHANISM KIT, LH (REPLACES EA20469-23/-24/-25)
					1	1		D412-711-101	REPLACEMENT WINDOW (REPLACES EAGLE P/N EB212-100L / EA20469-3)
					1	1		D3802-1-120	RUBBER STRIP
							2	D3932-1	SNAP VENT
					1	1		D4165-1	DOUBLER
					1	1		D4165-3	DOOR INNER SKIN (REPLACES EA20469-18)
					1	1		* D4165-5	AFT RIB (REPLACES EA20469-34)
					1	1		** D4165-7	FWD RIB (REPLACES EA20469-31)
					1	1		D4165-9	ANGLE (REPLACES EA20469-17)
					1	1		D4165-11	DOOR COVER PANEL (REPLACES EA20469-21)
					1	1		D4207-1	WINDOW RETAINER (REPLACES EA20469 -14)
					1	1		D4207-3	WINDOW (REPLACES EA20469-13)
					1	1		* D4269-1	ANGLE (REPLACES EA20469-33)
					1	1		** D4269-3	ANGLE (REPLACES EA20469-30)
					1	1		** D4269-5	ANGLE (REPLACES EA20469-29)
					1	1		* D4269-7	ANGLE (REPLACES EA20469-32)
					1	1		D4324-011	ARM REST ASSEMBLY (REPLACES EA20469-16)
					1	1		D4327-1	ANGLE (REPLACES EA20469-11)
					1	1		D4327-3	ANGLE (REPLACES EA20469-07)
					2	2		D4385-1	PLACARD

* PART OF EA20469-10 REAR RIB ASSEMBLY

** PART OF EA20469-12 FWD RIB ASSEMBLY

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. L
MFG. APPR.	N/A	D412-711	SHEET 2 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	VERTICAL REFERENCE DOOR	NTS
DATE	17.01.20	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 165245

Thursday, August 17, 2017 9:12:12 AM

165245

Page 1

Item ID: D412-711-021

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Vertical Reference Door Modification LH

Start Date: 8/28/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/12/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711	L								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefiles and create labels per PPP D412-711-021 CHG002								
120	Pick Kit	0.00							
120	Purchasing								
Packaging	Memo	0.00							
Packaging									
130	QC4- 100% Inspect kits for completeness	0.00							
130									
QC	Memo	0.03							
Quality Control									

17/9/5



Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Rd. N.E.
Calgary, AB
T2E 7G9

Number: SH92-30

Issue No.: 3

Approval Date: 1992 October 02

Issue Date: 2001 October 02

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Bell 204B

Canadian Type Certificate or Equivalent:

H1SW

Description of Type Design Change:

Installation of a Vertical Reference Door, with provisions for left seat operations.

Installation/Operating Data,
Required Equipment and Limitations:

Installation of the Vertical Reference Door, with left seat operation provisions, shall be done in accordance with the Transport Canada approved installation documents of Eagle Copters Ltd., Document Control List A20469DCL1, Rev 8, dated 30 August 2000, or later approved revision.

Transport Canada approved, Eagle Copters Ltd., Flight Manual Supplement EA204-69-20, Revision 1, dated 3 September 1992, or later approved revision, is required.

If the holder agrees to permit another person to use this certificate to alter the product, the holder shall give the other person written evidence of that permission.



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.

F.J.B. Wright
For Minister of Transport



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Eagle Copters Ltd.
823 McTavish Road N.E.
Calgary, Alberta
Canada T2E 7G9

Number: SH92-54

Issue No.: 4

Approval Date: October 01, 1992

Issue Date: January 15, 2008

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

BELL 205A, 205A-1, 205B

Canadian Type Certificate or Equivalent:

BELL 205B H-104
BELL 205A, 205A-1 H1SW

Description of Type Design Change:

Installation of vertical reference door, with provisions for left seat operation.

Installation/Operating Data,

Required Equipment and Limitations:

Installation of the vertical reference door, with provisions for left seat operation, shall be done in accordance with the installation documents of Transport Canada approved, Eagle Copters Ltd., Document Control List A20469DCL1, Revision 10, dated 18 December 2007, or later approved revision.

Transport Canada approved, Eagle Copters Ltd., Flight Manual Supplement EA205-69-20, Revision 3, dated 9 January 2008, or later approved revision, is required.

Dart Aerospace Ltd., Instructions for Continued Airworthiness ICA-D412-711 Rev 0, or later accepted revision, are applicable with this installation.

The basis of certification for this modification was FAR 29 at Amdt 29-16 except 29.1 at Amdt 29-21, FAR 29.151 at Amdt 29-24, FAR 29.1303 at Amdt 29-24, FAR 29.1529 at Amdt 29-20, and FAR 29.1587 at Amdt 29-21.

End

Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.



D.S. Austen
For Minister of Transport